



Dart Aerospace Ltd.
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BLH

D119-646-043
Job Sheet 199115



Part No: D119-646-043

Job Qty: 1 pcs

Part Name: AW119 Replacement Skidtube with Wearpads, Float Compatible - Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/13/19

Job Tracking No:

Due Date: 9/10/19

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: IIN-D119-646 REV.D, D3905-041 REV.F IPP RevA: New issue DD verified by:EC IPP revB 10.02.22 per PAR 09-043 EC verified by:DD IPP REVC 12.11.05 (DEOD3905-B-1)(ecn 12-675) DD verf:JLM IPP REV:D 13.03.20 per chg003 ECN13-534 DD verf:JLM IPP REV:E 15.01.19 AS PER ECN-14-628 DD verf:JLM IPP REV:F 16.11.02 chg as per D3905 revD(DEO) DD verf:JLM IPP REV:G 17.05.23 as per dwg D3905 rev.e DD verf:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	9/10/19		0.00	3.68	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3	<i>MGA</i>	<i>MGA</i>
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
120	Handfinish - 1-1 Chemical-B4B	1 pcs	9/10/19		0.00	1.56	Handfinish - 1 - 1 - B4B		<i>BEB 19-08-22</i>
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		
							Handfinish - 1 - 4 - B4B		
							Handfinish - 1 - 5 - B4B		
							Handfinish - 1 - 6 - B4B		
							Handfinish - 1 - 7 - B4B		
							Handfinish - 1 - 8 - B4B		
							Handfinish - 1 - 9 - B4B		
							Handfinish - 1 - 10 - B4B		
							Handfinish - 1 - 11 - B4B		
							Handfinish - 1 - 12 - B4B		
							Handfinish - 1 - 13 - B4B		
							Handfinish - 1 - 14 - B4B		
							Handfinish - 1 - 15 - B4B		



Container No: S207476



Part: D119-646-043

Job No: 199115

Serial No/Batch: S207476

Revision: D,F

Inspector:

Exp Date:

Instructions: FAA STC SR02024SE 18/10/17, TC STC LoA P.

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					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
					QC 7 - 10	
130 QC 7	1 pcs	9/10/19	0.00	0.00	QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	MGC
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
140 QC 5	1 pcs	9/10/19	0.00	0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	BE
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	

170 Skidtubes - 2 - B4B	1 pcs	9/10/19	0.00 3.68	QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	MAC
				Skidtubes - 4 - B4B	
180 QC 5	1 pcs	9/10/19	0.00 0.00	Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	BE
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
190 Skidtubes - 3 - B4B	1 pcs	9/10/19	0.00 3.68	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	MAC
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	BE
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
200 QC 5	1 pcs	9/10/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
210 QC 10	1 pcs	9/10/19	0.00 0.00		

					QC 10 - 43	
					QC 10 - 50	EL
					QC 10 - 58	
					QC 10 - 9	
					Handfinish - 2 - 1 - B4B	
220 Handfinish - 2-1 Pressure- B4B	1 pcs	9/10/19	0.00 1.56		Handfinish - 2 - 2 - B4B	
					Handfinish - 2 - 3 - B4B	
					Handfinish - 2 - 4 - B4B	Sub
					Spray Paint - 1 - B4B	
					Spray Paint - 2 - B4B	RD/9-4-31
230 Spray Paint - 2 - B4B	1 pcs	9/10/19	0.00 0.42		Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
					ATE003-VC	
235 Outsource	1 pcs	9/10/19				
240 QC 14	1 pcs	9/10/19	0.00 0.00		QC 14 - 15	EL 19-4-3
					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 41	
					QC 14 - 51	
					QC 14 - 58	
					QC 14 - 59	
					QC 14 - 9	
					QC 14 - 68	
					QC 14 - 40	
					QC 14 - 19	
					QC 14 - 43	
					QC 14 - 24	
					QC 14 - 61	
					QC 14 - 81	
250 Handfinish - 4-1-Assembly- B4B	1 pcs	9/10/19	0.00 1.56		Handfinish - 4 - 1 - B4B	EL 19-4-3
					Handfinish - 4 - 10 - B4B	
					Handfinish - 4 - 11 - B4B	
					Handfinish - 4 - 12 - B4B	
					Handfinish - 4 - 13 - B4B	
					Handfinish - 4 - 14 - B4B	
					Handfinish - 4 - 15 - B4B	
					Handfinish - 4 - 2 - B4B	
					Handfinish - 4 - 3 - B4B	
					Handfinish - 4 - 4 - B4B	
					Handfinish - 4 - 5 - B4B	
					Handfinish - 4 - 6 - B4B	
					Handfinish - 4 - 7 - B4B	
					Handfinish - 4 - 8 - B4B	
					Handfinish - 4 - 9 - B4B	
260 QC 5	1 pcs	9/10/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	DAS
					QC 5 - 19	10
					QC 5 - 22	9-89
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	

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					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
270 Handfinish - 4-2-Assembly-B4B	1 pcs	9/10/19	0.00	1.56	Handfinish - 4 - 1 - B4B	ML 14-9-1
					Handfinish - 4 - 10 - B4B	
					Handfinish - 4 - 11 - B4B	
					Handfinish - 4 - 12 - B4B	
					Handfinish - 4 - 13 - B4B	
					Handfinish - 4 - 14 - B4B	
					Handfinish - 4 - 15 - B4B	
					Handfinish - 4 - 2 - B4B	
					Handfinish - 4 - 3 - B4B	
					Handfinish - 4 - 4 - B4B	
					Handfinish - 4 - 5 - B4B	
					Handfinish - 4 - 6 - B4B	
					Handfinish - 4 - 7 - B4B	
					Handfinish - 4 - 8 - B4B	
					Handfinish - 4 - 9 - B4B	
280 QC 5	1 pcs	9/10/19	0.00	0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	DAG
					QC 5 - 49	19
					QC 5 - 51	2-00
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
285 Handfinish - 3-1- WingWalk-B4B	1 pcs	9/10/19	0.00	1.56	Handfinish - 3 - 1 - B4B	ML 15-9-1
					Handfinish - 3 - 2 - B4B	
					Handfinish - 3 - 3 - B4B	
					Handfinish - 3 - 4 - B4B	
					Handfinish - 3 - 5 - B4B	
286 QC 5	1 pcs	9/10/19	0.00	0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	

				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	DAS SEP 04 2019 40 9-59
				QC 5 - 61	
				QC 5 - 81	
295	Packaging 3-1 - Stock - B4B	1	9/10/19	0.00 0.00	Packaging 3 - 1 - B4B
	pcs				Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
297	DC - 1 - B4B	1	9/10/19	0.00 0.00	DC - 1 - B4B
	pcs				DC - 2 - B4B
300	QC 21 - FG	1	9/10/19	0.00 0.00	QC 21 - FG - 21
	pcs				QC 21 - FG - 70
					QC 21 - SA - 53
Part Op 110 - (Skid tubes) 1- Bend FWD end of tube using Bender 1 and bend prog D3905 FWD per dwg D3905 (FOLIO -04) 2- Descriptions: Cut FWD end of tube as per dwg D3905. 3- Cut AFT end of tube as per dwg D3905. 4- Buff out marks left from bending 5 -Install drill Jig DT9480 drill X-bolt spacer pilot holes using 3/16" drill first side only. 6- 2nd side, locating from first saddle holes use DT9861 A/B to drill 2nd side fwd saddle holes. 7- 2nd side locating from fwd saddle drill remaining crossbolt					

spacer holes usin DT9480 8- Drill FWD cap holes using DT8215.

120 - (Chemical Conversion Coat per QSI005 4.1)

130 - (QC7-Inspect Chemical Conversion Coat)

140 - (QC5- Inspect part completeness to step on W/O)

170 - (Skidtubes) Open FWD Saddle holes to finish size as per dwg and deburr 1-Bond web in place as per Dwg D3905 & QSI 015. (at 42.95" ref.) A/R Sikaflex-291 5200625 Sikaflex expire date: 20-07-25 Start:

Time: 4:10pm Finish: _____ Time: 4:10pm ***** (Adhere for 12 hours) ***** 2--Bend AFT

end of tube using CNC Bender 1 and bend prog. D3905 AFT as per dwg D3905. Install drop pins in crossbolt spacer holes to maintain web position. 3- Drill 1.87" and 3.74 holes using DT10045 A&B locate from FWD saddle hole. (verify measurement) as per dwg. 4- Drill Tow ring hole using DT10047. Open to finished size. 5- Open FWD & AFT cap holes

per dwg. Countersink Fwd cap only as per detail "C" 6-Open crossbolt spacer holes to finished size. Drill most Fwd wearplate holes using DT9816 (15.21") 7-Deburr crossbolt spacer holes as per Dwg D3905 and blow out chips from

inside the tube 8- Drill holes for wearpads using DT9613 & D DT9545

180 - (QC5- Inspect part completeness to step on W/O)

190 - (Skidtubes) NOTE:TACK IN 2 MOST FWD X-BOLT SPACERS AND TEST FIT FWD GROUND HANDLING

FIXTURE,IF FIXTURE FITS WELL THEN PROCEED. FIXTURE DT10091. 1-Insert crossbolt spacers. Weld as per QSI 004 and Dwg D3905. Remember to back drill each hole before welding the other side. Use aluminum rod A/R Aluminum Rod 139011 2-Grind cross bolt welds flush as per Dwg D3905. Ensure no pin hole. 3-Counterbore 5/16" x 0.750" deep as per Dwg D3905. 4- Deburr & Scribe batch # on Aft end of tube. 5- Pick D2855-5 cap and transfer drill missing hole. Deburr and identify cap with skidtube batch#.

200 - (QC5- Inspect part completeness to step on W/O) TEST FIT USING FIXTURE DT10091.

210 - (QC10- Inspect visual per QSI004- ground welds)

220 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

230 - (Spray Paint / NDT Room) *****AS PER DETAIL"F" NOTE 8, SHEET 8 MASK THIS AREA, DO NOT APPLY PRIMER OR PAINT***** PRIME AS PER DWG AND QSI 005 4.2 BATCH: 5200299 PAINT WHITE AS PER DWG AND QSI 005 4.2 BATCH: 5204428

240 - QC14- Inspect Spray Paint)

250 - (Assemble as per dwg) 1-Install inserts as per Dwg D3905.

260 - (QC5- Inspect part completeness to step on W/O)

270 - (Assemble as per dwg) 1-Install wearpads, gaskets and wearplates as per Dwg D3905. Put sikaflex in insert before installing bolts and washers A/R Sikaflex-240/-291 5174347 Sikaflex expire date: 14-12-6 2-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: 5138847 3 -Inspect for foreign

objects as per QSI 024 4 -Install D2855-3 Cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291 5174347 Sikaflex expire date: 14-12-6 5 -Install insert in D2855- Cap. Install cap and seal with Sikaflex.

Clean excess adhesive. A/R Sikaflex-240/-291 5174347 Sikaflex expire date: 14-12-6 6- Install (2)D5101-041 and (1)D5101-047 as per dwg by using DT10117

280 - (QC5- Inspect part completeness to step on W/O)

285 - HandFinish3 (Wing Walk as per dwg QSI005 4.4 Batch _____)

286 - (QC5- Inspect part completeness to step on W/O)

295 - (Identify as per dwg & Stock Location: _____) Identify and pack for shipping as per PPP D119-646- Location: _____ PPP Rev: _____

297 - (Document Control) Photocopy bluefile &type labels per PPP D119-646-043 CHG 006

300 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2500-1-190	Ext'n - 'I' Beam Tube 4"	1 pcs (1 ea)	110-Skidtubes - 1	5168371
D3885-3	Float Web	1 pcs (1 ea)	170-Skidtubes - 2 - B4B	5197122
D2579	Crossbolt Spacer	2 pcs (2 ea)	190-Skidtubes - 3 - B4B	5097840
D2855-5	Cap	1 pcs (1 ea)	190-Skidtubes - 3 - B4B	502078
D3681-1	Spacer	12 pcs (12 ea)	190-Skidtubes - 3 - B4B	5188347 x 4 5145873 x 8
D3903-1	Spacer	12 pcs (12 ea)	190-Skidtubes - 3 - B4B	5184432
ALS4-1032-130	Rivnut	42 Ea (42 ea)	250-Handfinish - 4-1-Assembly-B4B	5057257
D3683-3	Insert	12 pcs (12 ea)	250-Handfinish - 4-1-Assembly-B4B	5172308
ALS4-1032-225	Rivnut	1 Ea (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5180214
AN3C4A	Bolt	6 Ea (6 ea)	270-Handfinish - 4-2-Assembly-B4B	5204570
AN3C5A	Bolt	38 Ea (38 ea)	270-Handfinish - 4-2-Assembly-B4B	5206460
AN4C46A	Bolt	3 Ea (3 ea)	270-Handfinish - 4-2-Assembly-B4B	5126407
D2855-3	Cap	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5193339
D3492-5	Plug	24 pcs (24 ea)	270-Handfinish - 4-2-Assembly-B4B	5164000
D3672-1	Washer, Phenolic	2 pcs (2 ea)	270-Handfinish - 4-2-Assembly-B4B	5142046
D3847-1	Wearpad	8 pcs (8 ea)	270-Handfinish - 4-2-Assembly-B4B	5136646
D3847-11	Wearpad	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5210627
D5101-041	Crossbolt Spacer Assembly	2 pcs (2 ea)	270-Handfinish - 4-2-Assembly-B4B	5145828
D5101-047	Crossbolt Spacer Assembly	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5143976
D5101-3	Insert	6 pcs (6 ea)	270-Handfinish - 4-2-Assembly-B4B	5198130
D5101-5	Insert	6 pcs (6 ea)	270-Handfinish - 4-2-Assembly-B4B	5067269
MS21043-4	Nut	3 Ea (3 ea)	270-Handfinish - 4-2-Assembly-B4B	x 10K
MS24694-C52	Screw	2 Ea (2 ea)	270-Handfinish - 4-2-Assembly-B4B	5193130
MS27039C4-08	Screw	12 Ea (12 ea)	270-Handfinish - 4-2-Assembly-B4B	
NAS1149C0332R	Washer (AN960C10L)	44 Ea (44 ea)	270-Handfinish - 4-2-Assembly-B4B	5180135
NAS1611-005	O-Ring	24 Ea (24 ea)	270-Handfinish - 4-2-Assembly-B4B	
NAS1149C0416R	Washer	6 Ea (6 ea)	270-Handfinish - 4-2-Assembly-B4B	5209072

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2500-1-190	1	65	0
170-Skidtubes - 2 - B4B	D3885-3	1	15	0
190-Skidtubes - 3 - B4B	D2579	2	91	0
	D2855-5	1	41	0
	D3681-1	12	84	0
	D3903-1	12	79	0
250-Handfinish - 4-1-Assembly-B4B	ALS4-1032-130	42	6,816	0
	D3683-3	12	218	0
270-Handfinish - 4-2-Assembly-B4B	ALS4-1032-225	1	1,206	0
	AN3C4A	6	1,130	0
	AN3C5A	38	930	0
	AN4C46A	3	74	0
	D2855-3	1	78	0
	D3492-5	24	292	0
	D3672-1	2	1,493	0
	D3847-1	8	21	0
	D3847-11	1	8	0
	D5101-041	2	2	0
	D5101-047	1	6	0
	D5101-3	6	24	0
	D5101-5	6	36	0
	MS21043-4	3	850	0
	MS24694-C52	2	60	0
	MS27039C4-08	12	212	0
	NAS1149C0332R	44	3,043	0
	NAS1149C0416R	6	100	0
	NAS1611-005	24	454	0

Part Specifications

Specifications could not be found.

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D3905-041 FLOAT SKIDTUBE ASSY WITH WEARPAD (SHOWN)
D3905-043 FLOAT SKIDTUBE ASSY WITH WEARPLATE (SIMILAR)
D3905-045 FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE (SIMILAR)

[illegible]

APPROVED

THE UNIVERSITY OF CHICAGO

2018 OCT 19
ECM 19-7-10

DRAWING NO.

CHECKED ; **MM**

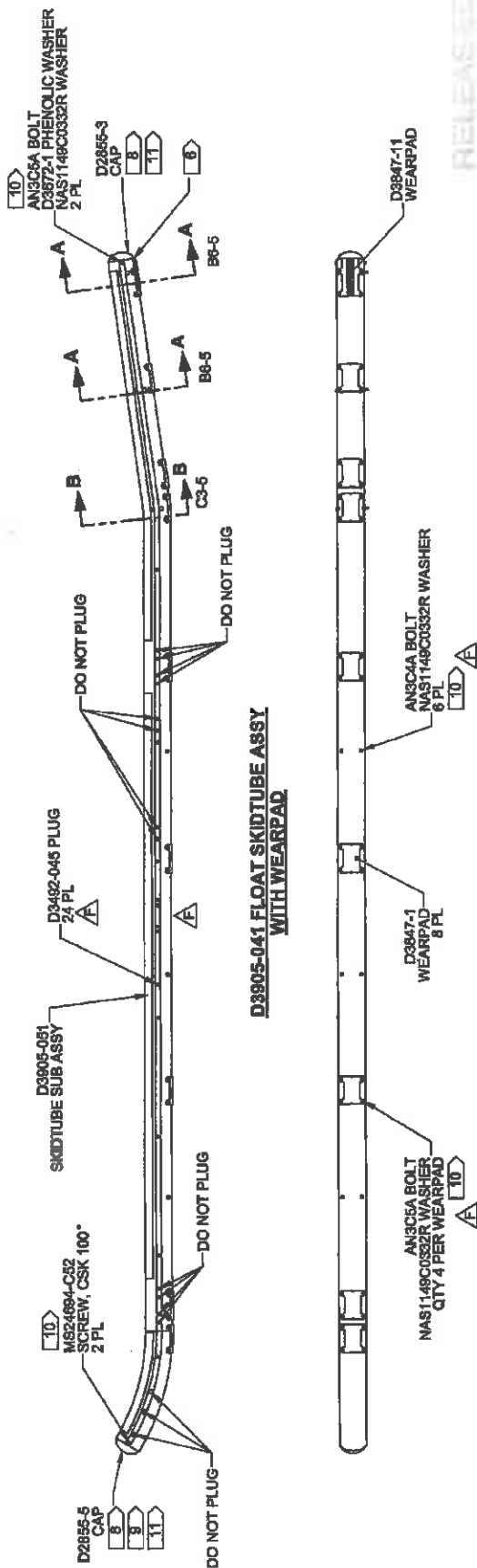
61 130 B107
2018 OCT 19

2018 OCT 19
PM 19:37

8 7 6 5 4 3 2 1

ITEM	QTY -041	PIN	DESCRIPTION
1	1	D3805-041	SKIDTUBE ASSY
2	1	D2855-3	CAP
3	24	D3492-045	PLUG
4	2	D3872-1	PHENOLIC WASHER
5	8	D3847-11	WEARPAD
6	1	D3847-11	WEARPAD
7	1	D3805-081	SKIDTUBE SUB ASSEMBLY
8	2	D5101-041	CROSSBOLT SPACER ASSY
9	1	D5101-047	CROSSBOLT SPACER ASSY
10	6	D5101-3	INSERT
11	6	D5101-5	INSERT

ITEM	QTY -041	PIN	DESCRIPTION
12	1	ALS4-1032-225	INSERT
13	8	AN3C4A	BOLT
14	38	AN3C5A	BOLT
15	3	AN4C48A	BOLT
16	3	MS21045-4	NUT, SELF-LOCKING
17	2	MS24694-C52	SCREW, CSK 100°
18	44	NAS1149C0332R	WASHER
19	6	NAS1149C0416R	WASHER



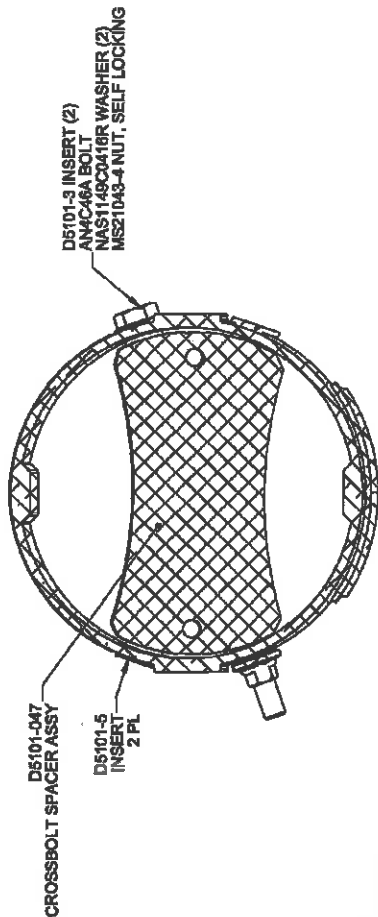
D3805-041 FLOAT SKIDTUBE ASSY
WITH WEARPAD

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART PIN "D3805-041" AND BATCH NUMBER PER QSI 044 8.4 ON THE ID OF THE TUBE, BEFORE INSTALLING THE AFT D2855-3 CAP
 - 7) WEIGHT: 35.4 lbs
 - 8) RELIEVE INNER RIDGE OF EXTRUSION, AS NEEDED, TO ALLOW FOR INSTALLATION OF D2855-3 AND D2855-5 CAP ASSY. ALDOINE BARE MATERIAL
 - 9) USE D3805-081 SKIDTUBE ASSY TO LOCATE AND BACKDRILL UNDRILLED INSERT HOLE INTO D2855-6 CAP, OPEN HOLE TO Ø0.287, ALDOINE BARE MATERIAL AND INSTALL ALS4-1032-225 (OR ANS7-1032-225, OR ALS7-1032-225) INSERT ON INSIDE OF CAP.
 - 10) SEAL FASTENERS WITH SIKAFLEX -241-291 OR PROSEAL 880 OR MIL-S-8802 CLASS B2 SEALANT
 - 11) SEAL MATING SURFACES WITH SIKAFLEX -241/291 OR PROSEAL 880 OR MIL-S-8802 CLASS B2 SEALANT

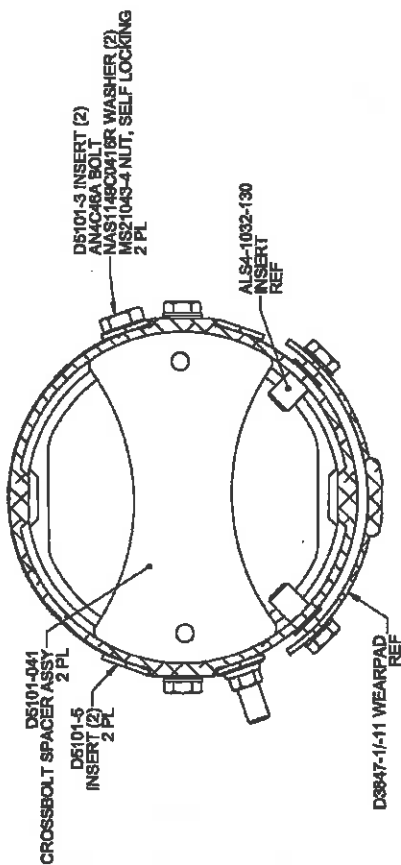
DESIGN	ASB	REV. F
DRAWN	ZF	EUGENE, OR
CHECKED	MW	DART AEROSPACE USA, INC.
MFG. APPR.	DD	DRAWING NO. D3905
DE APPR.	DS	TITLE A119 FLOAT SKIDTUBE ASSY
DATE	18.08.16	SHEET 2 OF 14
		SCALE
		NTS
		COPYRIGHT © 2008 BY DART AEROSPACE USA, INC.
		THE MATERIALS AND WORKMANSHIP OF THIS DRAWING ARE HEREBY GUARANTEED TO MEET THE REQUIREMENTS OF THE SPECIFICATION TO WHICH IT IS REFERRED.

1 2 3 4 5 6 7 8

D C B A



SECTION B-B
SCALE 12X



SECTION A-A
SCALE 12X

RELEASED
JAN 21 1961

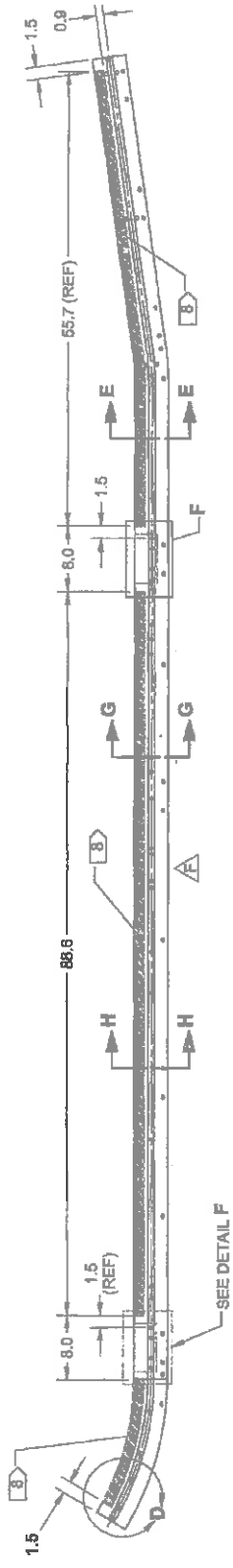
DESIGN	ALS	DART AEROSPACE USA, INC.	REV. F
DRAWN	ZF	EUGENE, OR	
CHECKED	MW	DRAWING NO. D3905	SHEET 5 OF 14
MFG. APPR.	DD	TITLE	SCALE
APPROVED	NO		
DE APPR.	D3	A119 FLOAT SKIDTUBE ASSY	NTS
DATE	18.08.16		

APPROVED

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8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
-	X	D3905-051	SKIDTUBE SUB ASSY
1	2	D2579	CROSS BOLT SPACER
2	12	D3681-1	SPACER
3	12	D3903-1	SPACER
4	1	D3905-081	SKIDTUBE SUB ASSEMBLY
5	42	AL 54-1032-130	INSERT



D3905-051 SKIDTUBE SUB ASSEMBLY

RELEASED
JUN 10 1994

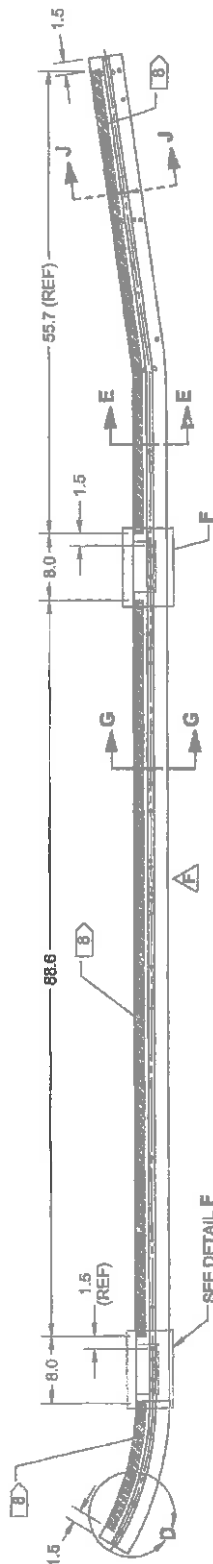
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: PRIME (REF 4.2.1.3.3) AND PAINT: WHITE PER DART Q81 005 4.2.2.4
 - 3) TOLERANCES: PER DART Q81 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY AT NEXT ASSEMBLY
 - 7) WEIGHT: N/A
 - 8) AFTER APPLICATION OF FINISH, PAINT TOP SURFACE OF SKIDTUBE WITH MIL-W-5044 ANTI-SKID PAINT (WING WALK) AS INDICATED TO 0.50" ABOVE LOCATION RIDGE, PER Q81 005 SECTION 4.4

DESIGN	AJS	DART AEROSPACE USA, INC.
DRAWN	ZF	EUGENE OR
CHECKED	MW	DRAWING NO. D3905
MFG. APPR.	DD	REV. F
APPROVED	NO	SHEET 6 OF 14
DE APPR.	DS	TITLE A119 FLOAT SKIDTUBE ASSY
DATE	18.08.16	SCALE NTS

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8 7 6 5 4 3 2 1

ITEM	QTY -063	P/N	DESCRIPTION
	X	D3905-083	SKIDTUBE SUB ASSY
1	2	D2679	CROSS BOLT SPACER
2	12	D3901-1	SPACER
3	12	D3903-1	SPACER
4	1	D3905-083	SKIDTUBE SUB ASSEMBLY
5	10	ALS4-1032-130	INSERT

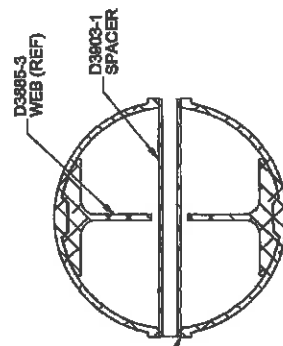


D3905-053 SKIDTUBE SUB ASSEMBLY

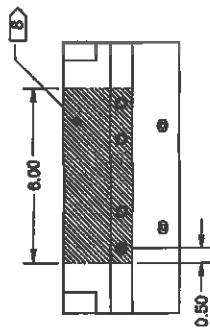
- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: PRIME (REF 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2.2.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY AT NEXT ASSEMBLY
 - 7) WEIGHT: N/A
 - 8) AFTER APPLICATION OF FINISH, PAINT TOP SURFACE OF SKIDTUBE WITH MIL-W-5044 ANTI-SKID PAINT (WING WALK) AS INDICATED TO 0.50" ABOVE LOCATION RIDGE, PER QSI 006 SECTION 4.4

DESIGN	AS	DART AEROSPACE USA, INC.	
DRAWN	ZF	EUGENE, OR	
CHECKED	MW	DRAWING NO.	REV. F
MFG. APPR.	DD	D3905	SHEET 7 OF 14
APPROVED	NO	TITLE	SCALE
DATE	18.08.16	A119 FLOAT SKIDTUBE ASSY NTS	

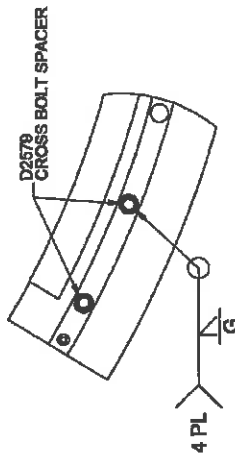
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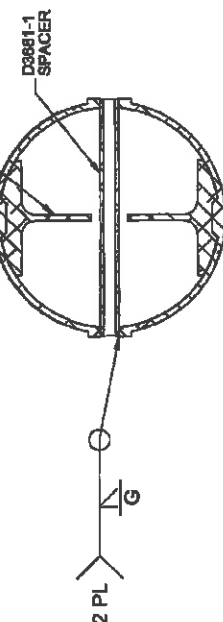
SECTION G-G
SCALE: 7X
12 PL



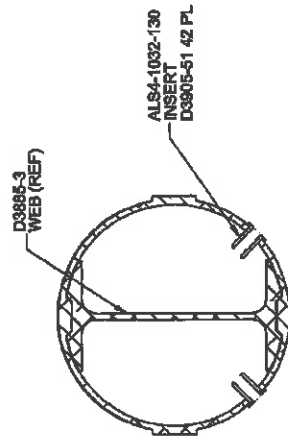
DETAIL F
SCALE: 3.5X



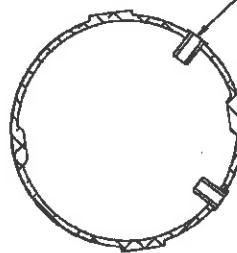
DETAIL D
SCALE: 3.5X



SECTION E-E
SCALE: 7X
12 PL



SECTION H-H
SCALE: 7X
D3805-51 21 PL



SECTION J-J
SCALE: 7X
D3805-53 5 PL

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: PRIME (REF 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2.2.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
 - 7) WEIGHT: N/A
 - 8) MASK THIS AREA AND DO NOT APPLY PRIMER OR PAINT
 - 9) AFTER DRILLING AND BENDING ASSEMBLY, PERFORM THE FOLLOWING FOR THE SECTION G-G $\phi 0.375$ HOLES ONLY:
 - i) CHAMFER HOLES $\phi 0.475 \times 45^\circ$
 - ii) INSERT D3803-1 SPACER
 - iii) WELD INTO PLACE AND GRIND FLUSH
 - iv) C/BORE TO $\phi 0.313 \times 0.75$ DEEP
 - v) DEBURR HOLES
 - 10) AFTER DRILLING AND BENDING ASSEMBLY, PERFORM THE FOLLOWING FOR THE SECTION E-E $\phi 0.313$ HOLES ONLY:
 - i) CHAMFER HOLES $\phi 0.354 \times 46^\circ$ OR 0.050 DEEP $\times 45^\circ$ (BOTH SIDES)
 - ii) INSERT D3803-1 SPACER
 - iii) WELD INTO PLACE AND GRIND FLUSH
 - iv) DEBURR HOLES
 - 11) WELD PER DART QSI 004

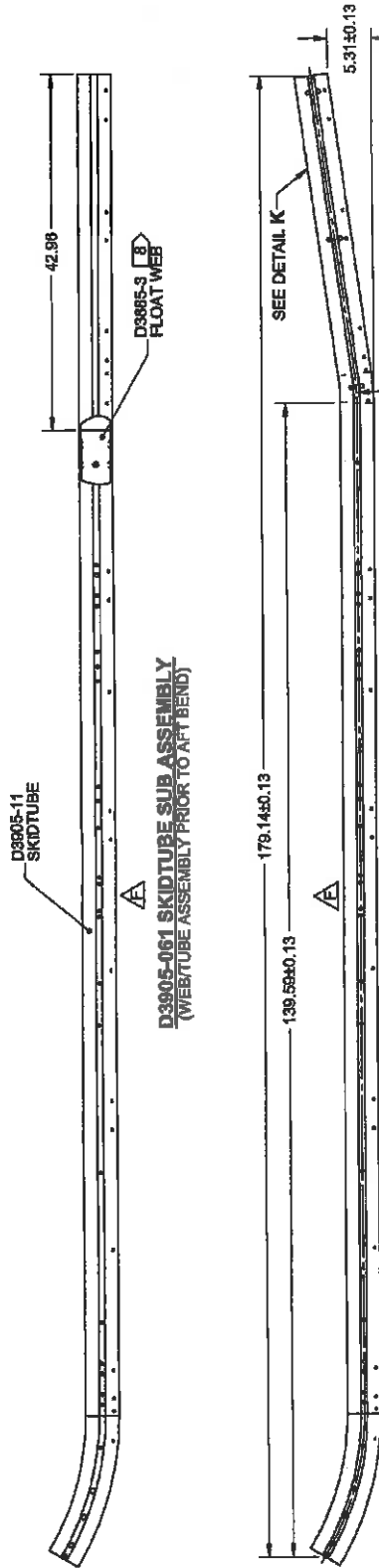
DESIGN	AJS	REV. F
DRAWN	ZF	DRAWING NO. D3805
CHECKED	MW	REV. F
MFG. APPR.	DD	SHEET 8 OF 14
APPROVED	NO	SCALE
DATE	18.08.16	TITLE
		A119 FLOAT SKIDTUBE ASSY
		NTS

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EUGENE, OR

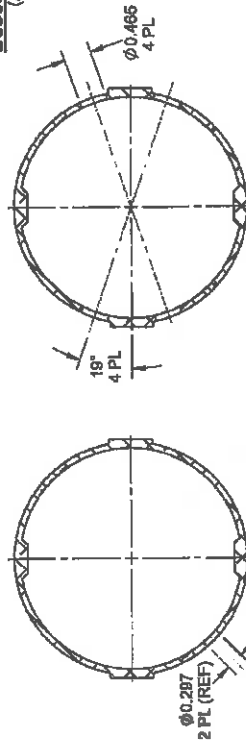
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ITEM	QTY	P/N	DESCRIPTION
	X	D3905-001	SKIDTUBE SUB ASSEMBLY
1	1	D3905-3	FLOAT WEB
2	1	D3905-11	SKIDTUBE



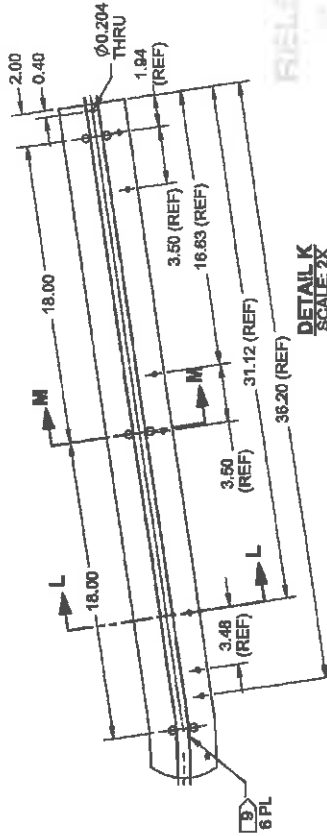
D3905-061 SKIDTUBE SUB ASSEMBLY
(WEB/TUBE ASSEMBLY PRIOR TO AFT BEND)

D3905-061 SKIDTUBE SUB ASSEMBLY
(AFT BEND AND DRILLING DETAILS)



SECTION M-M
3 PL
SCALE: 7X

SECTION L-L
7 PL
SCALE: 7X

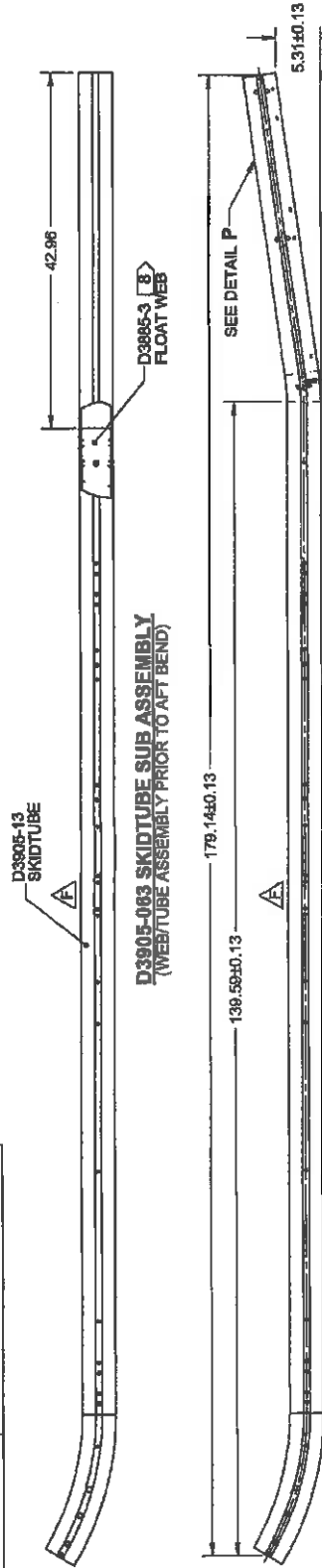


DETAIL K
SCALE: 2X

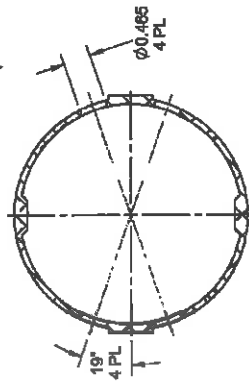
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
 - 7) WEIGHT: N/A
 - 8) INSERT D3905-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE
 - 9) WITH SIKAFLEX-241/281 ADHESIVE PER DART QSI 015 AFTER BENDING. ENSURE HOLES LINE-UP
 - 10) RELIEVE RIDGE FLUSH WITH SKIDTUBE FOR INSERT CLEARANCE, MAX 0.130 INTO RIDGE

DESIGN	A/S	DATE	18.08.16
DRAWN	ZF	DRAWING NO.	D3905
CHECKED	MW	NO	NO
MPG. APPR.	DD	TITLE	A119 FLOAT SKIDTUBE ASSY
APPROVED	NO	SCALE	NTS
DE APPR.	DE	SHEET 9 OF 14	REV F
DATE	18.08.16	DART AEROSPACE USA, INC. EUGENE, OR	

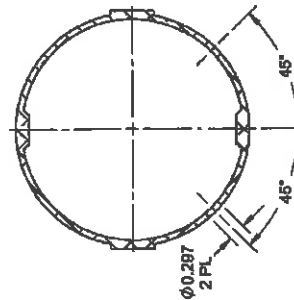
ITEM	QTY	PIN	DESCRIPTION
1	X	D3905-063	SKIDTUBE SUB ASSEMBLY
2	1	D3885-3	FLOAT WEB
3	1	D3905-13	SKIDTUBE



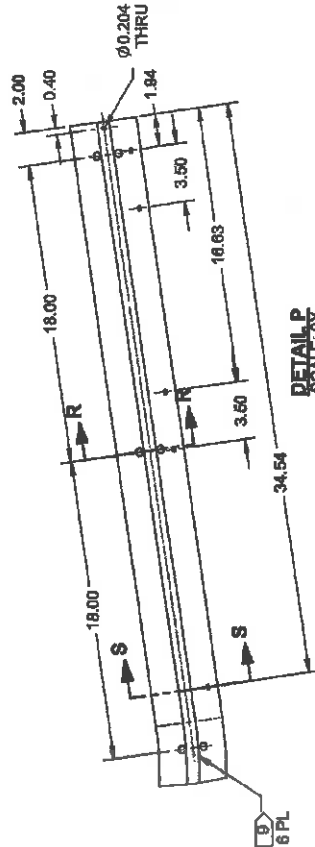
D3905-063 SKIDTUBE SUB ASSEMBLY
(AFT BEND AND DRILLING DETAILS)



SECTION R-R
3 PL
SCALE: 7X



SECTION S-S
6 PL
SCALE: 7X



DETAIL P
SCALE: 2X

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER PART QSI 003 4.1
 - 3) TOLERANCES: PER PART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
 - 7) WEIGHT: N/A
 - 8) INSERT D3885-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH SIKARLEX-241/291 ADHESIVE PER PART QSI 015 AFTER BENDING. ENSURE HOLES LINE-UP
 - 9) RELIEVE RIDGE FLUSH WITH SKIDTUBE FOR INSERT CLEARANCE, MAX 0.130 INTO RIDGE

DESIGN	AJS	DATE	18.08.16
DRAWN	ZF	EDGEMORE, OR	
CHECKED	MMW	DRAWING NO.	D3905
MFG. APPR.	NO	TITLE	A119 FLOAT SKIDTUBE ASSY
DE APPR.	DE	SCALE	10 OF 14
		SHEET	10 OF 14
		REV. F	

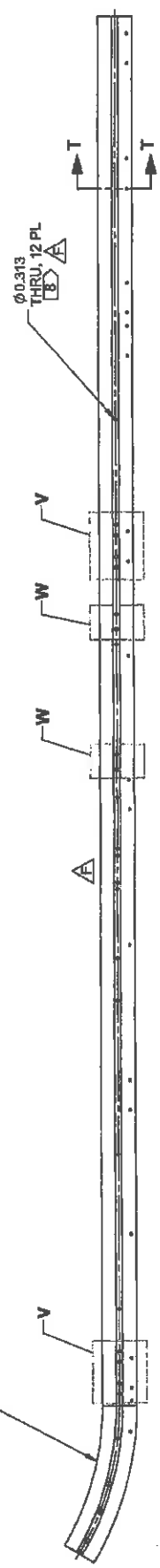
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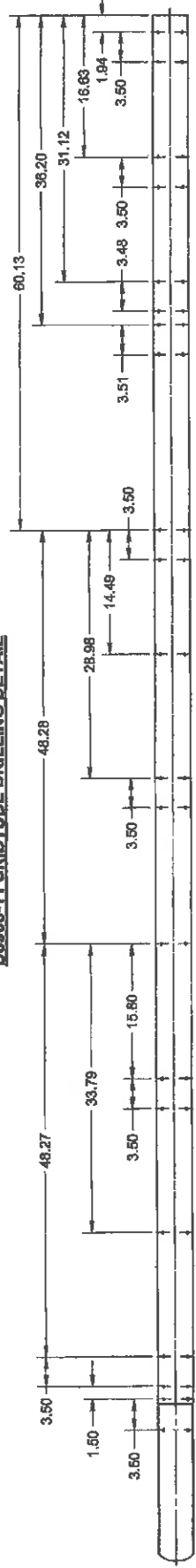
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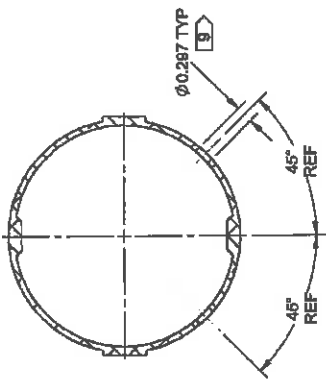
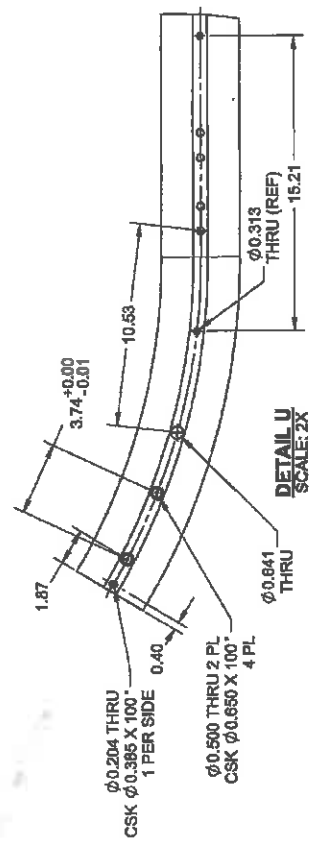
SEE DETAIL U



D3905-11 SKIDTUBE DRILLING DETAIL



WEARPAD/WEARPLATE HOLE PATTERN
FOR REFERENCE ONLY
DRILL USING DT9813/DT8545 TEMPLATE



SECTION J-I
SCALE: 2X
21 PL

- NOTES:
- 1) MATERIAL: MAKE -11 DRILL DETAIL FROM -1 FWD BEND DETAIL
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART Q81 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.006 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
 - 7) WEIGHT: N/A
 - 8) PICK UP ON PILOT HOLES
 - 9) USE DART DRILL TEMPLATE DT9813/DT8545 TO LOCATE AND DRILL 0.0287 HOLES FOR WEARPAD/WEARPLATE INSERTS.

DESIGN	A/S	DATE	18.08.16
DRAWN	ZF	DATE	18.08.16
CHECKED	MW	DATE	18.08.16
MFG. APPR.	DD	DATE	18.08.16
APPROVED	NO	DATE	18.08.16
DE APPR.	DS	DATE	18.08.16
DART AEROSPACE USA, INC.			
EUGENE, OR			
DRAWING NO. D3905			
REV. F			
SHEET 11 OF 14			
SCALE			
TITLE			
A119 FLOAT SKIDTUBE ASSY			
NTS			
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